

Work Order ID 70487 LH



Thursday, June 09, 2011 3:18:17 PM

Item ID: D206-642-151

Revision ID:

Item Name: Replacement Skidtube

Start Date: 6/9/2011 Start Qty: 1.00

Required Date: 6/20/2011 Req'd Qty: 1.00

Reference:

Left HAND

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-06-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3804	A								
IIN-D206-642	N								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151 CHG001

NA [Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D206-642-151

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Revision ID:

Stop



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110



Skidtubes

Skidtubes

0.00

0.00

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☒ M112860 / M117456

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8166 + DT8169D

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

30

BE 11/07/07

Dr. 10/07/07

BE 11/08/10

Dart Aerospace Ltd

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Run Start



Stop



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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

BE 11/08/18

120



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

8 11/08/19

✓

Dart Aerospace Ltd

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140 Chemical Conversion Coat per QSI005 4.1

0.00

Ae 11.08.29



HandFinish

Memo

0.00

(X)

Ø

Hand Finishing

150 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

1

Ø

BE11/09/08

Quality Control

160 Skidtubes

0.00



Skidtubes

Memo

0.00

1

Ø

BE11/09/08

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

Dart Aerospace Ltd

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

5 ulozlog

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☐ 6/9/13 ☐ Time: ☐ 2:00 ☐Finish Date: ☐ 6/9/13 ☐ Time: ☐ 8:00 ☐

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Sikaflex-291 ☐ m118393 ☐Sikaflex expire date: ☐ 12/6/13 ☐*8E11/09/13*

Dart Aerospace Ltd

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 u/02/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



Skidtubes

Skidtubes

0.00

Memo

1-remove alodine from around hole and prepare for welding

BE 11/09/16

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐

M112860

BE 11/09/16

3-Grind welds flush as per Dwg D3804.

SL 11/09/19

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐

NONE

BE 11/09/21

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr



11-9-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

DP 11-9-21

P10

220

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

11.10.04

Qc10 →

230

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 6/12/04

Dart Aerospace Ltd

(1911)

W/O: 70487		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-157 PAR #: NP Fault Category: Landing Gear / SLD NCR: Yes No DQA: Date: 11.10.22
 Resolution: Re work Disposition: Re work QA: N/C Closed Date: 11/10/25

NCR: 11-907		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/22	#200	Found at inspection that the 19th hole from aft (1st saddle hole) doesn't align in one line R.C. Pulled when welding / Process	CP 11.09.22	- Drill out + Remove 19th 19th x-bolt spacer - Re weld Q1 x1 D2648 B 73057 A/R 117004 As per 657.004	CP 11-10-3 BE 11/10/03	S 11/10/04	CP 11.09.22 PS1012	S 11/09/22
			CP 11.09.22	- Remove 19th x-bolt - Grind welds. - Re centre Bore + Deburr	CP 11-10-3 S 11/10/04	S 11/10/04	CP 11.09.22	S 11/09/22

NOTE: Date & initial all entries

Work Order ID 70487

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Setup Start



Revision ID:

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Start Date: 6/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1XØ M-L 11/10/04

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:45
320°F
9:15

1XØ M-L 11/10/05

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 of 10 11/10/05

M118439

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install
plugs as per Dwg D3804. Clean excess adhesive.

1 0 M 11/10/05

280

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/R ☐ Sikaflex-291 ☒ 11/18/05
Sikaflex expire date: ☐ 12/05

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4
Batch: 11/18/05

1 0 M 11/10/05

Dart Aerospace Ltd

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290 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

8 u/l o/ o7

300 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

8 u/l o/ o7

310 Packaging 0.00



Packaging Memo 0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev: PPR 24402

Dart Aerospace Ltd

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Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/20 [Signature]
MF
11-10-19

Dart Aerospace Ltd

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Thursday, June 09, 2011 3:18:25 PM



Required Date: 6/20/2011.

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERE:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No				Each	12.0000		1		8/11/07/07	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG			12						
				62684			1						
				68135			1						
				68136			10						
D3286-1  Doubler		Manufactured	No				Each	36.0000		2		8/11/08/08	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG002			36						
				52844			15						
				64563			21						
D2647  Cap		Manufactured	No				Each	30.0000		1		8/11/07/07	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG002			30						
				55352			30						

Dart Aerospace Ltd

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Picklist Print

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Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased No

Each

678.0000

52



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

678

115698

39

116471

139

117816

500

26

D2654-1

Manufactured No

Each

0.0000

1



Web

D2649

Manufactured No

Each

207.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

195

68224

40

70394

155

LG001

12

65317

1

68507

11

D3286-3

Manufactured No

Each

31.0000

2



Spacer

Location

Loc Qty

Loc Code

LG002

31

46643

1

64564

30

2

BE 11/09/13
M118686 *29

BE 11/09/13
B64562

BE 11/09/13
B64562
BE 11/09/13
B 73390 *17

BE 11/09/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 09, 2011 3:18:26 PM

Work Order ID: 70487

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased No

Each

581.0000

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

579

117086

79

117849

500

② DP 11-9-21

CR3212-4-03

Purchased No

Each

1,228.000

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1226

114859

1226

② DP 11-9-21

D2680-041

Manufactured No

Each

36.0000

1



Nut Plate

Location

Loc Qty

Loc Code

ST020

36

55366

17

70088

19

① DP 11-9-21

D3805-041

Manufactured No

Each

2.0000

1



Wearplate Assembly Fwd, Low Gear

Location

Loc Qty

Loc Code

FP

2

64565

2

B73813 X1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 70487

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3805-045 Manufactured No

Each 2.0000



Wearplate Assembly Aft, Low Gear



1
21110105

Location

Loc Qty

Loc Code

FP

2

B7377

21

64566

2

Each

255.0000



7
21110105

AN3-37A

Purchased No



Bolt

Location

Loc Qty

Loc Code

ST353

205

105425

69

111668

136

27

ST354

50

117619

50

AN960JD10

NAS1149D0363J

Purchased No



Washer

Each

0.0000

21118077



7
(x7) 21110105

MS21042L3

Purchased No



Nut

Each

2,322.000



7
21110105

Location

Loc Qty

Loc Code

ST300

2322

116391

9

116549

613

117441

800

117601

400

117885

500

21118451

27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, June 09, 2011 3:18:26 PM

Work Order ID: 70487

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

Each 112.0000

14



Bushing



ulioios

Location

Loc Qty

Loc Code

ST084

100

1370690

x14

68247

100

ST088

12

64760

12

AN960JD416 NAS1149D0463J Purchased No

Each 0.0000

1



Washer

x118384



(x1) ulioios

D2651-1 Manufactured No

Each 248.0000

6



Plug



ulioios

Location

Loc Qty

Loc Code

fpa

121

69018

121

FP-A

127

57869

7

66445

10

67263

12

67760

98

D2651-3 Manufactured No

Each 576.0000

6



O-Ring



ulioios

Location

Loc Qty

Loc Code

FP-A

576

61962

132

66956

444

x6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, June 09, 2011 3:18:26 PM

Work Order ID: 70487

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06 Purchased No

Each 61.0000



1
JH 11/10/05

Screw

Location	Loc Qty	Loc Code
FP-A	26	
115460	26	
ST292	35	
115460	35	

XL

D2646 Manufactured No

Each 24.0000



1
JH 11/10/05

Aft Cap

Location	Loc Qty	Loc Code
FP006	23	
62678	23	
FP-4	1	
69019	1	

B71070

XL

MS27039-1-08 Purchased No

Each 768.0000



2
JH 11/10/05

Screw

Location	Loc Qty	Loc Code
ST291	768	
115108	468	
117423	300	

M118378

X2

AN960JD10L NAS1149D0332J Purchased No

Each 0.0000



2
(x2) JH 11/10/05

Washer

M117087

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70487
011-06-9

RELEASED
09.03.03
per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>97</u>	DART AEROSPACE USA, INC	
DRAWN	<u>97</u>	PORT HADLOCK, WA	
CHECKED	<u>97</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>97</u>	D3804	SHEET 1 OF 5
APPROVED	<u>97</u>	TITLE	SCALE
DE APPR.	<u>97</u>	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Initial all entries

approved QAWCRWO RevE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

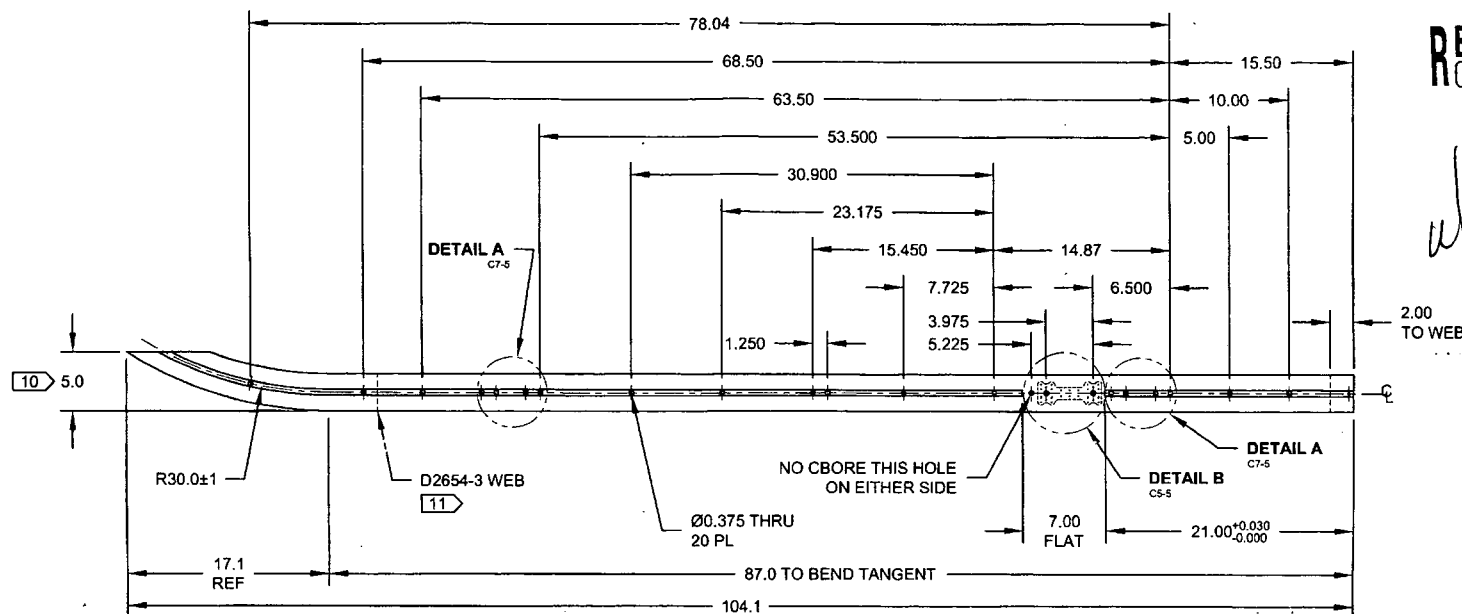
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

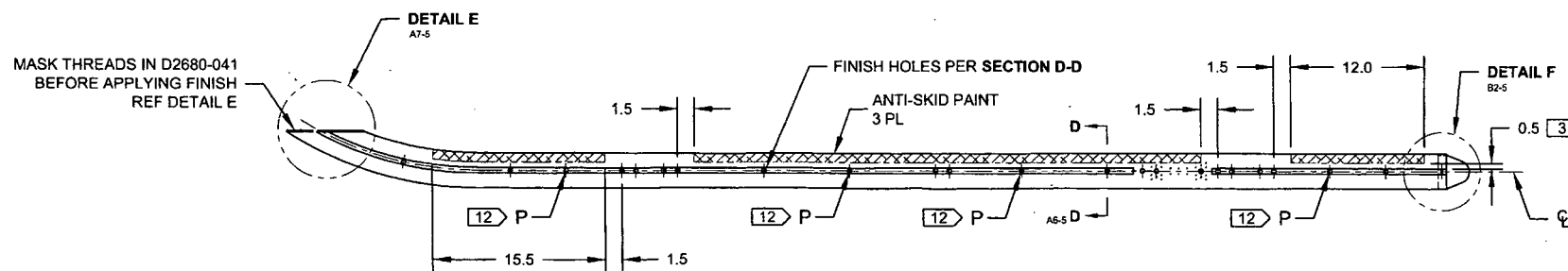
NOTE: Date & initial all entries

RELEASED
09-03-03

u/o 70487



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 3 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Dart Aerospace Ltd

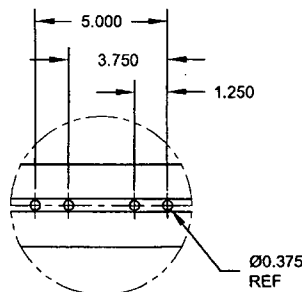
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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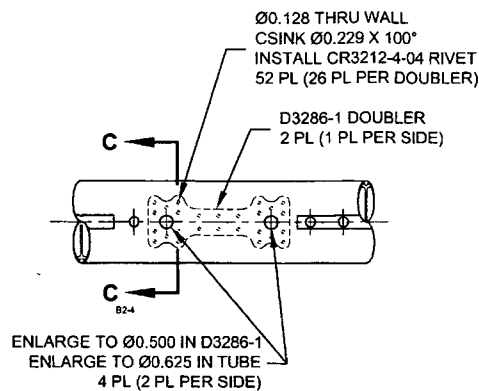
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



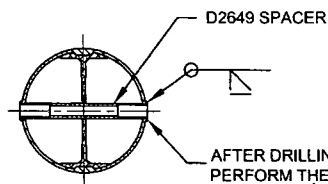
DETAIL A
SCALE NONE

D5-2
C2-2
D5-3
C2-3



DETAIL B
SCALE NONE

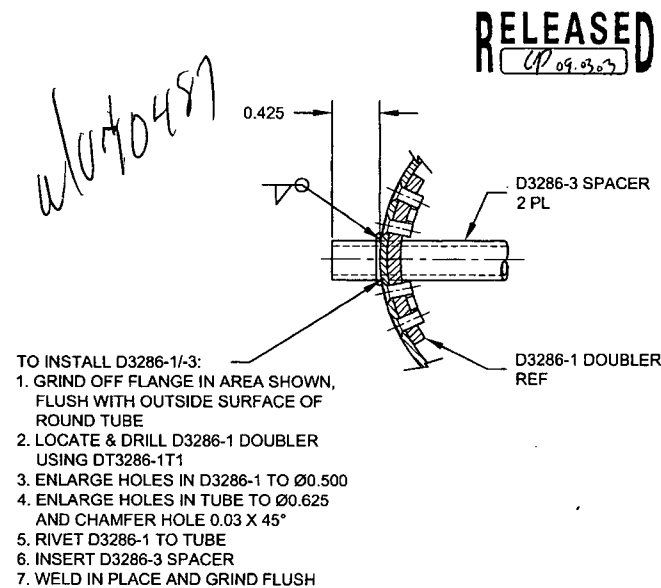
C3-2
C3-3



SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE

- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

A4-2
A4-3



SECTION C-C
PARTIAL SECTION
SCALE NONE

C6-4

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
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RELEASED
UP 09.03.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
97 09.03.03

26 70487

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE A7-5

0.400

END OF WEB

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

DETAIL F
SCALE NONE B2-2
B2-3

D2647 CAP, TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

MS27039-4-06 SCREW
AN960JD416 WASHER

D2680-041
NUTPLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

1/16

DETAIL E
SCALE NONE B7-2
B7-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	2	DRAWING NO.	REV. A
MFG. APPR.	3	D3804	SHEET 5 OF 5
APPROVED	4	TITLE	SCALE
DE APPR.	5	SKIDTUBE ASSEMBLY, 206A/B	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

NO. 266

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 704089
Part number: 5206 642 151
Description: 206
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier John Jones Date of Test Coupon 11.09.22

Welder Barclay Elliott Date of Test Coupon 11.09.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld